

**Work Order ID 58343**

Page 1

Monday, May 03, 2010 2:58:41 PM

Item ID: D3909-041

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug Assembly, Fwd

Stop



Start Date: 5/10/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 5/14/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: *MF*

Date: 10-5-3 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

D3909	B								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110		0.00							
Small Fab	Memo	0.00							
Small Fab	1- Assemble as per dwg Trim rivet to 1.185" long								
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

*JS 10/05/27 ⑥*

*EP 10/05/27 ⑥*

*S wls127*

*(46)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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Page 2

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Stop



**Start Date:** 5/10/2010 **Start Qty:** 6.00



**Cust Item ID:**

**Required Date:** 5/14/2010 **Req'd Qty:** 6.00



**Customer:**

**Reference:**

**Approvals:**

**Process Plan:**

**Date:**

**Tooling:**

**Date:**

Run

Start



**QC:**

**Date:**

**SPC (Y/N):**

**Date:**

Stop



**Sequence ID/  
Work Center ID**

130



**Operation  
Description**

Identify as per dwg & Stock Location: 476

**Set Up/  
Run Hours**

0.00

**Draw  
Number**

**Draw  
Rev.**

**Plan  
Code**

**Accept  
Qty**

**Reject  
Qty**

**Reject  
Number**

**Insp.  
Stamp**

16-5-27

6xJ

Packaging

**Memo**

0.00

140



QC21- Final Inspection - Work Order Release

0.00

QC

**Memo**

0.00

Quality Control

10/05/31 JF

MF  
10-5-27

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NOTE: Date & initial all entries

## Picklist Print

Page 1

Monday, May 03, 2010 2:58:40 PM

**Work Order ID:** 58343



**Parent Item:** D3909-04



**Parent Item Name:** Crosstube Lug Assembly, Fw

**Start Date:** 5/10/2010

Required Date: 5/14/2010

**Comments:** IPP RevA: New issue DD verified by:EC  
per dwg revB DD 10.04.20 verified by:EC

IPP Rev:B as

**Start Qty:** 6.00

**Required Qty:** 6.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Picklist Print

Page 2

Monday, May 03, 2010 2:58:40 PM

**Work Order ID:** 58343



**Parent Item:** D3909-041



**Parent Item Name:** Crosstube Lug Assembly, Fwd

Start Date: 5/10/2010

Required Date: 5/14/2010

**Comments:** IPP RevA: New issue DD verified by:EC  
per dwg revB DD 10.04.20 verified by:EC

IPP Rev:B as

**Start Qty:** 6.00

**Required Qty:** 6.00

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Page 3

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**Required Qty: 6.00**

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Page 4

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Required Date: 5/14/2010

Comments: IPP RevA: New issue DD verified by:EC  
per dwg revB DD 10.04.20 verified by:EC

IPP Rev:B as

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
NAS1149C0332R		Purchased	No			100	Each	3,848.000	8		EBO/05/27	

Washer

Location      Loc Qty      Loc Code

ST297	3848	
113524	10	
113737	150	
114341	3688	

NAS1149C0363R

Purchased

No

100 Each 1,199.000

2



48

12

Location      Loc Qty      Loc Code

ST297	1199	
113422	35	
113524	464	
113644	200	
113889	500	

W/O:		WORK ORDER CHANGES					
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

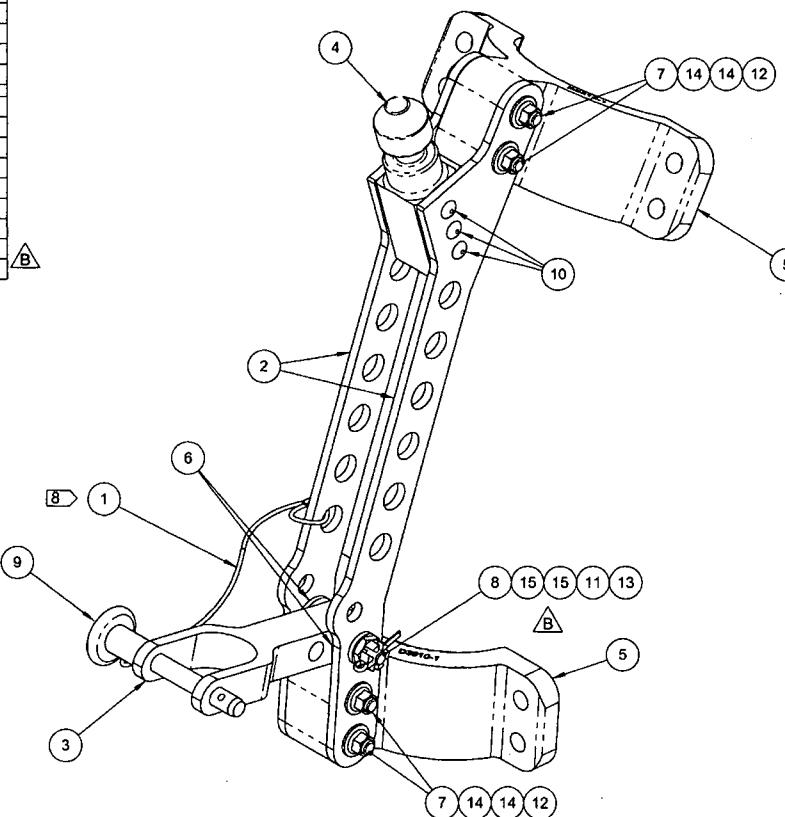
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
X	1	D3909-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	2	D3909-1	FWD X-TUBE LUG PLATE
3	1	D3909-3	FWD LOWER ATTACH ARM
4	1	D3909-5	EYEBOLT STUD
5	2	D3910-1	X-TUBE LUG
6	2	D3917-1	WASHER
7	4	AN3C12A	BOLT
8	1	AN3C13	BOLT
9	1	MS17984-C413	PIP PIN
10	3	MS20615-4M20	RIVET
11	1	AN310C3	NUT - CASTELLATED
12	4	MS21043-3	NUT
13	1	MS24665-151	COTTER PIN
14	8	NAS1149C0332R	WASHER
15	2	NAS1149C0363R	WASHER

B



D3909-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.74 lbs
- 8) ATTACH TO D3909-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING

B	BOM: ADDED ITEM 15 QTY 2 NAS1149C0363R ADDED, ITEM 14 QTY 8 WAS 10. SHT 5, D3909-5 REVISED: SECTION A-A & DIM Ø0.650 REMOVED. SIDE VIEW ADDED. DIM: 2.68 WAS 2.38 REF. 1.30 WAS 1.00, 0.250 WAS 0.220, R0.06 WAS R0.05. WEIGHT REVISED.			JPH	10.04.06
A	NEW ISSUE			JPH	10.03.04
REV.	DESCRIPTION			BY	DATE
DESIGN	JPH	DART AEROSPACE LTD			A
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA			
CHECKED	<i>[Signature]</i>	DRAWING NO.			REV. B
MFG. APPR.	<i>[Signature]</i>	D3909			SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE			SCALE
DE APPR.	<i>[Signature]</i>	FWD X-TUBE LUG ASSY			NTS
DATE	10.04.06			COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

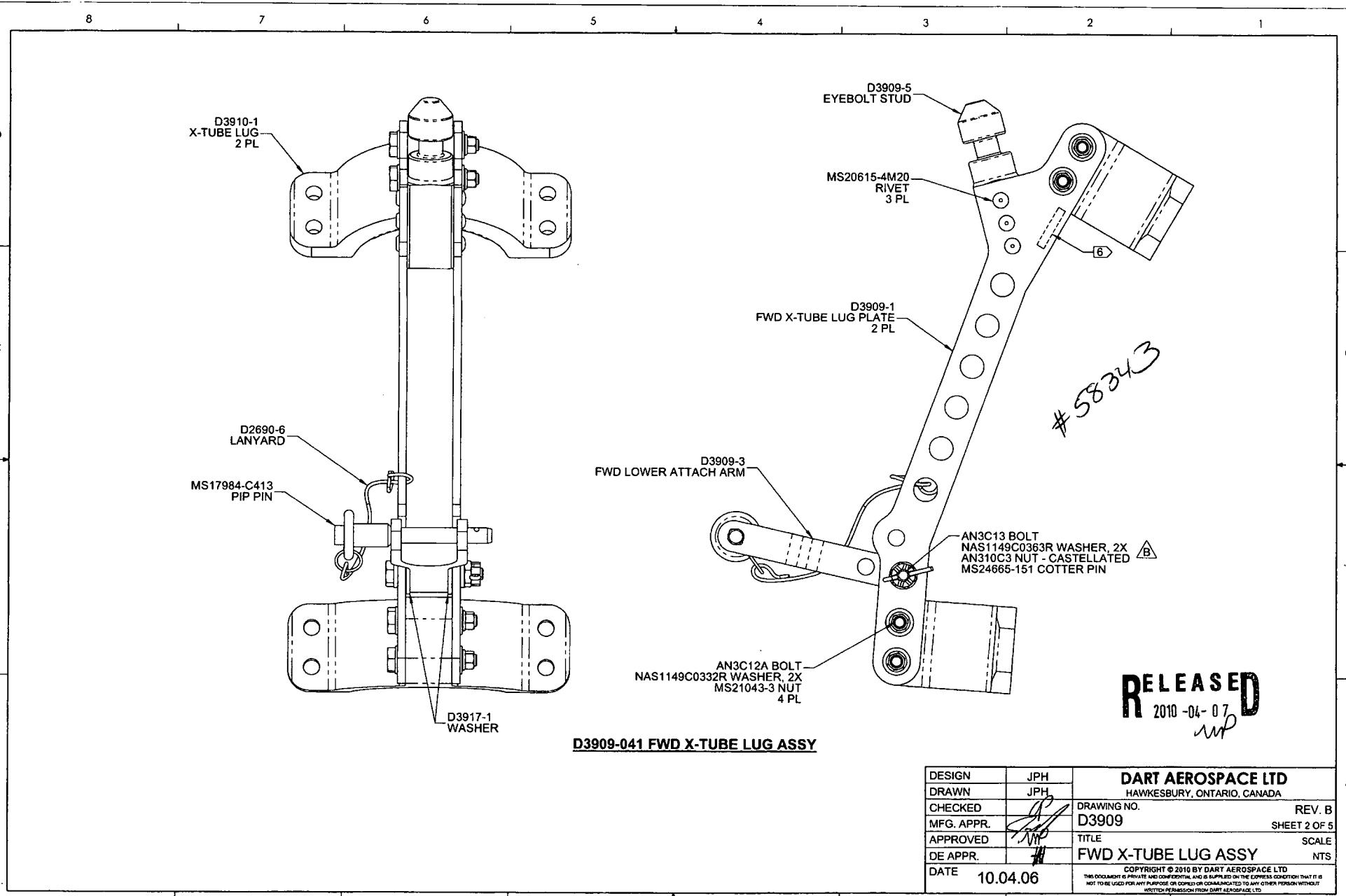
8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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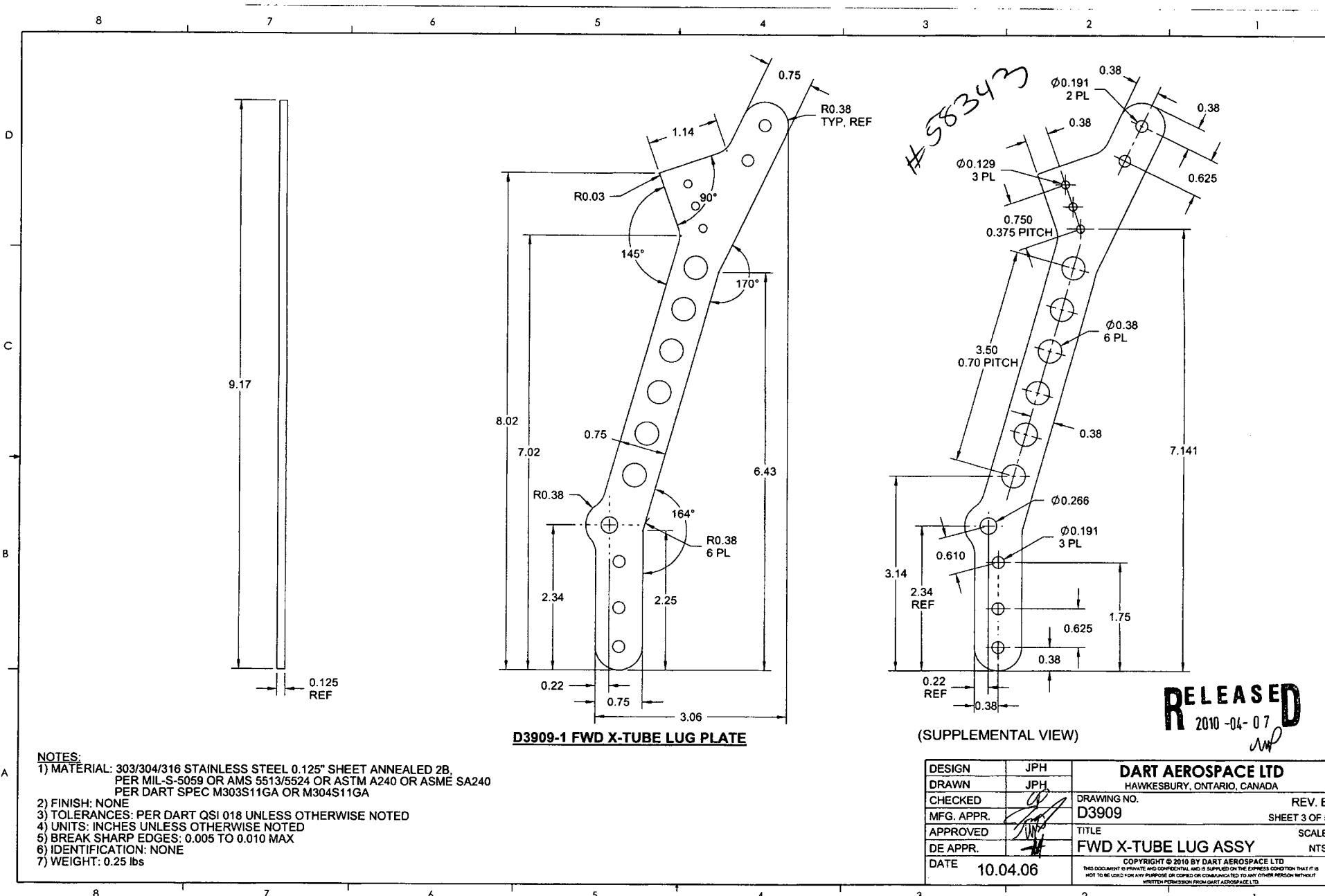


W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



RELEASED  
2010-04-07  
*[Signature]*

(SUPPLEMENTAL VIEW

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>CD</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>CD</i>	D3909	SHEET 3 OF
APPROVED	<i>LIN</i>	TITLE	SCALE
DE APPR.	<i>CD</i>	FWD X-TUBE LUG ASSY NTS	
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W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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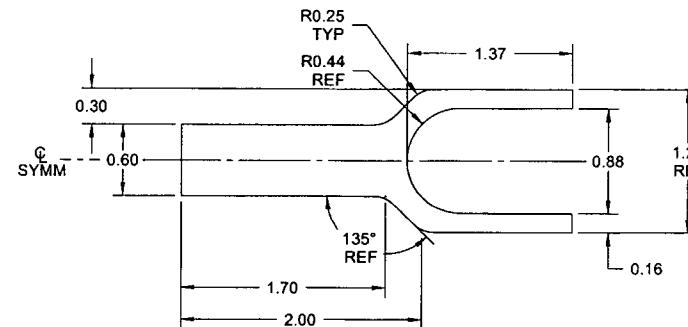
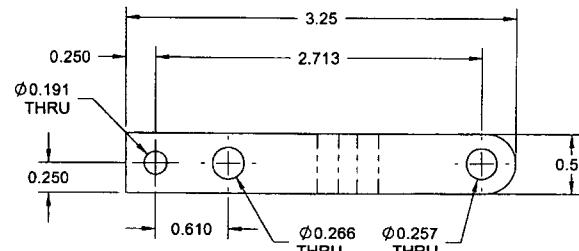
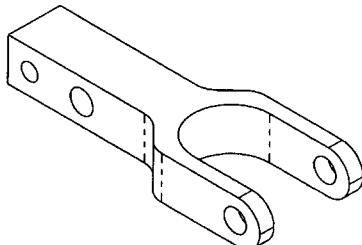
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**D3909-3 FWD LOWER ATTACH ARM**

**RELEASED**  
2010-04-07  
*[Handwritten signature]*

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276  
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs

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DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3909	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FWD X-TUBE LUG ASSY	NTS
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NOTE: Date & initial all entries

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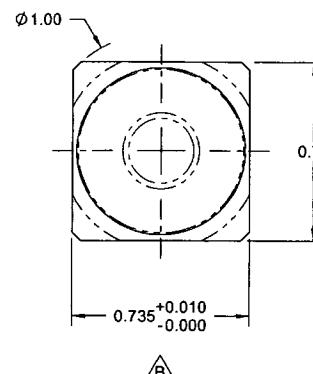
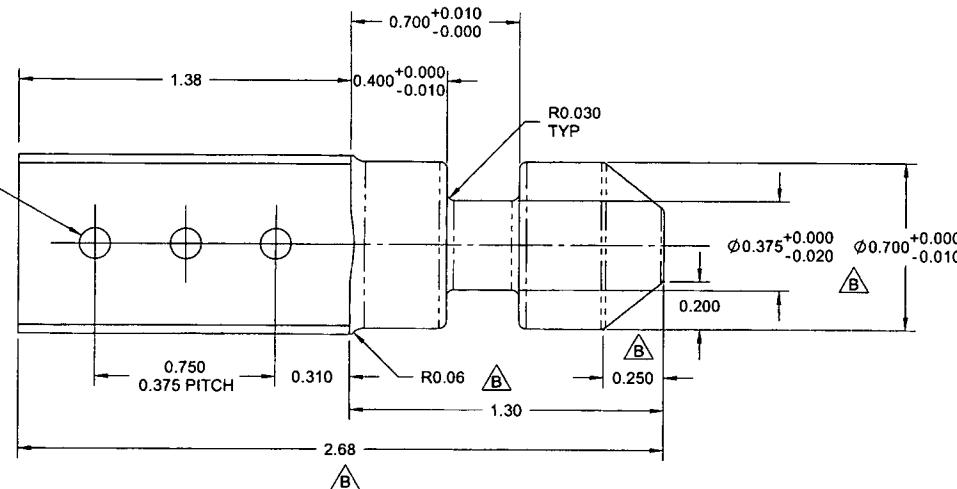
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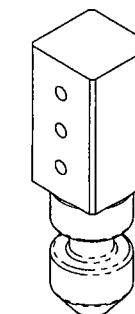
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 $\phi 0.129$  THRU  
TYP

#56343



### D3909-5 EYEBOLT STUD

#### NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276  
PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.31 lbs

RELEASED  
2010-04-07  
JMP

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.		D3909	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FWD X-TUBE LUG ASSY	
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